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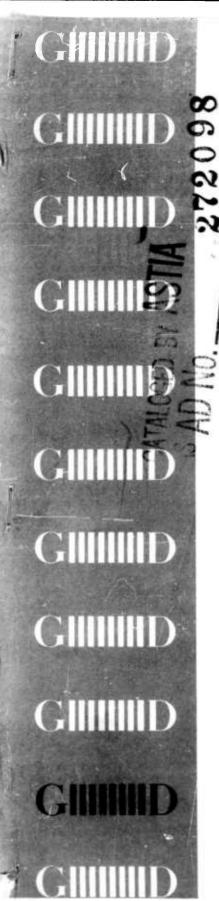
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REPORT NO: FGT-2454 DATE: 15 JANUARY 1962

FASTENERS - SCREWS & RIVETS ON STEEL SHEET SHEAR & BEARING PROPERTIES - DETERMINATION OF

PUBLISHED AND DISTRIBUTED UNDER CONTRACT NO: AF33(657)-7248

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GENERAL DYNAMICS | FORT WORTH

A DIVISION OF GENERAL DYNAMICS CORPORATION
(FORT WORTH)

TEST F-5873
MODEL B-58

REPORT <u>FGT-2454</u>

DATE 12-16-1959

GROUP: METALLURGICAL Engineering Test Laboratories

TITLE

FASTENERS - SCREWS & RIVETS ON STEEL SHEET

SHEAR & BEARING PROPERTIES - DETERMINATION OF

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(FORT WORTH)

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FASTENERS - SCREWS & RIVETS ON STEEL SHEET SHEAR & BEARING PROPERTIES - DETERMINATION OF

PURPOSE:

The purpose of this test was to determine the yield and ultimate shear and bearing strengths of AN 509 screws, NAS 177 rivets, and RIV 165 rivets mounted in SAE 4130 and 17-7PH stainless steel.sheet.

SUMMARY:

Tests were conducted to determine the effects of sheet thickness on the shear and bearing properties of fasteners. Several sheet thicknesses were tested with each fastener. Fasteners from 3/16" to 1/2 diameter and sheet thicknesses of from .025" to .312" were used in the tests. The sheet materials used were SAE 4130 steel heat treated to 150 ksi and 17-7PH stainless steel in the TH 1050 condition.

The data obtained was tabulated and graphs were drawn showing joint strength versus sheet thickness for each type of fastener tested.

* RIV 165 is the Convair Stock Number for the Hi-Shear Co. Part No. HS67 - Hi-Shear Rivet, 100° Csk Head, 125 ksi shear strength, CRES material.

UTILITY REPORT SHEET

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(FORT WORTH)

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FASTENERS - SCREWS & RIVETS ON STEEL SHEET SHEAR & BEARING PROPERTIES - DETERMINATION OF

OBJECT:

The object of this investigation was to determine the yield and ultimate shear and bearing strengths of the following combinations of fasteners and sheet:

- 1. AN 509 screws, 3/16" to 1/2" in diameter mounted in SAE 4130 steel heat treated to 150 ksi and 17-7PH-TH1050 stainless steel in various gages from .032" to .312".
- 2. NAS 177 rivets, 1/8" diameter to 3/8" diameter mounted in SAE 4130 steel heat treated to 150 ksi and 17-7PH-TH1050 stainless steel in gages from .025" to .180".
- 3. RIV 165 rivets, 1/8" to 1/2" diameter mounted in SAE 4130 steel heat treated to 150 ksi and 17-7PH-TH1050 stainless steel in gages of .025" to .312".

DESCRIPTION OF SPECIMENS:

Figure 1 is a sketch of the type specimen used. Exact dimensions of each type specimen were varied to suit the size of the fasteners and the thickness of plates being tested. All specimens were of the general configuration shown and conformed to the requirements listed in Figure 1. The fasteners ranged from 1/8" to 1/2" in diameter. The plates varied from .025" to .312" in thickness. The two e/D ratios were 1.5 and 2.0.

PROCEDURE:

All the material used for the specimens was obtained from in-plant stock. The specimens were fabricated at Convair-FW according to FTJ-7108 and Mil-S-6758, and tested in the Engineering Metallurgy Laboratory.

Testing was done in a Baldwin Lima Hamilton universal test machine of 60,000 lbs. capacity. This machine was calibrated to provide an accuracy in load measurements of 0.2% of scale range or 0.5% of indicated load, which ever was greater. Deformation was measured with a PS5M extensometer.

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The manner of affixing the extensometer to the specimen caused considerable concern. At the start of the test, it was fastened directly to the test specimen by means of extension arms. The arms allowed it to be clamped to the centerline of the 2" width specimens. This arrangement had two disadvantages, the magnification obtainable was too high and the extension arms allowed some slippage to occur. The device illustrated in Figure 2 was constructed to overcome these two disadvantages. It was patterned after one developed by High Shear Rivet Tool Company, but was modified somewhat to suit these specimens and to fit into the 60,000 lb. test machine. The magnification of this fixture combined with the extensometer was determined by calibration against two materials of known modulus using 2" wide strips as specimens. The results obtained from these two materials agreed within 1.5%. The balance of the test specimens, approximately 95% of the specimens, were then tested using this fixture.

The yield point was taken from the autographic curves at a permanent offset of 2 1/2% of the shank diameter of the fastener being tested. The method of taking the yield strength is shown graphially in Figure 3. To obtain the yield strength, the specimens were loaded to near an estimated yield point, and then unloaded to a low stress level. Loading was then resumed and continued to failure. This reloading caused a second curve to be traced. The reason for this procedure was that the first curve was influenced by the unavoidable play between the fasteners and the holes in the plates. The play was taken up by the load applied during the first part of the cycle. The second curve was therefore assumed to be the true curve and the yield was taken from it.

Failures were classified in three general types. Where the failure occurred by pulling the heads of the fasteners through the plates, or by pulling the fasteners through the ends of the plates, it was classed as a bearing failure. If the plates failed at some other point, such as near the grip ends, it was called a tensile failure. If the fasteners were sheared the failure was called a shear failure.

RESULTS:

The results of this investigation consist entirely of empirical data presented as follows:

Tables I thru VI - Yield & ultimate strength in tabular form. Figures 5 thru 27 - Yield & ultimate strength versus plate thickness in graphical form.

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DISCUSSION:

During the period in which these data were obtained, portions of the original test request were cancelled and some of the test specimens, or their identifications, were lost. Therefore, some of the possible joint configurations which were part of the original test request and which are indicated as part of this test under the heading "Object" were not tested.

In testing specimens of the geometry used in this test, some scatter in the data is to be expected. Actually, the test results in general showed less scatter than was anticipated.

Where scatter did occur in the yield strength values, it is felt that there were three contributing factors. The first was normal manufacturing tolerances. Although these tolerances were small, they created the possibility for one fastener to be loaded before the other. Another factor which may have effected some of the results was that many of the fasteners were considerably longer than the specification called for. In these cases, the excessive grip length was taken up with washers. On these specimens, the fastener tilted at high loads. This probably resulted in an unrealistic load distribution in the fastener and plates. The correct length fasteners were reportedly unavailable at the time the specimens were fabricated.

The curve shown in Figure 3 is an idealized one. Many of the actual curves were far more difficult to interpret. Small differences in selection of point "A" had no serious affect on the yield point determinations because the 2-1/2% permanent set was measured from point "O". The difficulties occurred in determining the slope of line MN. In many cases, there was no straight part of the curve at section CA, making it difficult to determine a slope for line MN.

CONCLUSIONS:

Since the object of this investigation was to ascertain the empirical data which was present in the Tables, no conclusions were drawn.

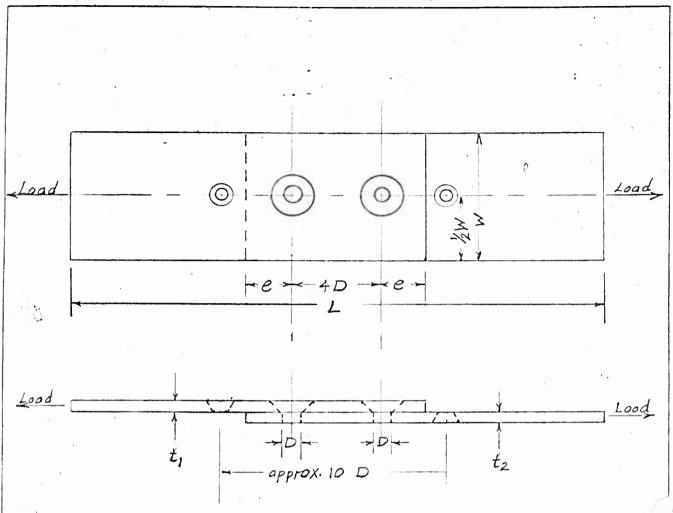
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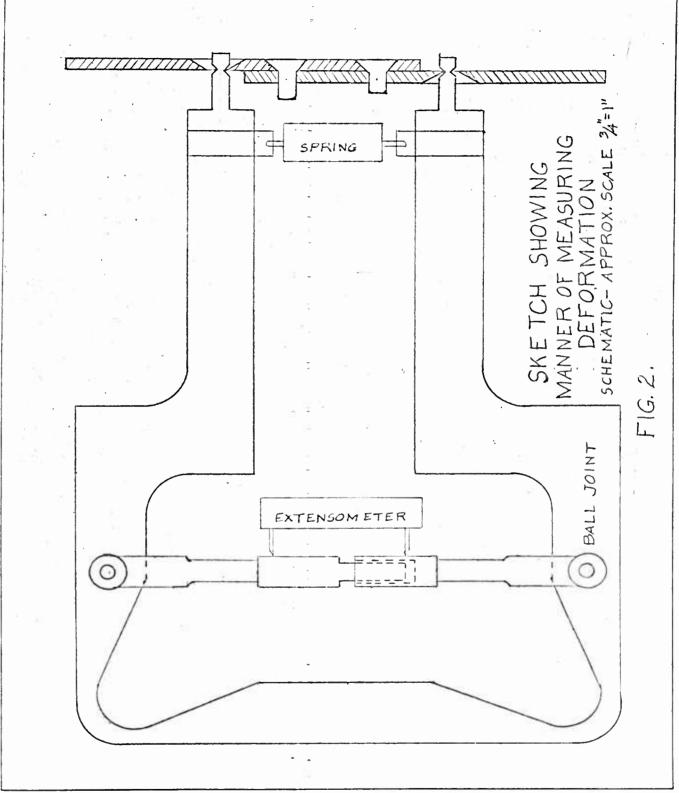
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CONVAIR—FORT WORTH
TABULATION SHEET TABLE I-AN 509 SCREWS IN 4130-150 H.T. ALLOY STEEL. Pg 1 CONVAIR — FORT WORTH

			Tage 32 FGT-2454
TYPE OF FAILURE	bearing tensile bearing shear	tensile y tensile	shear shear
10 F/457, 155 165. 1/2" 9260 9540 7180 8680 8220 9120	7240 11620 7720 11080 4000 9280 6320 10650 6950 15360 5920 15360 5920 15360	——————————————————————————————————————	24700 29400 24700 29400 16500 310 50 18170 29410
45 TENER PLATES RATIO N-509-816-22 2X5 4 X:063 1.5	-816-22 2X6 X.063 2.0	2 X 6 X . 125	2X6X.180 2X6X.250
SPECIMEN NO FASTENER 4-809-1 AN-509-816-22 -2 -3 Y Avg	2-845-1 AN 509-816-22 -2 -3 -3 -4 Avg	2-801-1 -2 -3 \ 4vg 3-841-1 -2 \ -3	3-833-1 -2 -3 -3 -3 -2 -3 -4 -3

TABULATION SHEET TABLE I CONT. AN 509 SCREWS IN 4130-150 H.T. ALLOY STEEL. Pg 2 CONVAIR — FORT WORTH

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6-					6050 1120	0	* e	
* AV9	>	~	-		5740 11735	2		
2-851-1	215	X5%X.125			70301460	OShear		
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3-871-1	2X5	2X5/2X.160			8650 1374	O shear		
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3-865-1	215	5 1/2 X.180			12600 14480	30 shear		
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5					13900 1560	0		
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4-831-1	AN 509-616-20 2X	5 % X.040	1.5	3/8"	738	30 bearing	0	
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(4)					6080 1460	20		
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CONVAIR -- FORT WORTH

. pg 3

-	FASTENER PLATES RATIO	2π	
5-2-5-1 AN 503	2 2 X 5 5/6 X. 140 1.5	3/8" 5760 12580 64000	All the state of the state
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5-857-1	2X55/6X.160	10670 12440 shear	
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5-851-1	2 X 5 7/6 X 1/80	12450 13600 shear	The second section of the second section of the second section of the second section s
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1-875-1 AN 509	509-516-192×51/4×.036 2.0	5/16" 3270 4190 bearing	and the same of th
		3575 4050	The state of the s
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Y ANG	<i>></i>	3360 4100 Y	entreligie fermine in der nach auch der
			Management days unto your about proper to be supported.
2-813-1	2X5/4X.100		The state of the s
2-3		6080 9640	The second secon
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2-5-1	2X51/4X.140	1008010640 shear	2
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Y Arg	<i>></i>	9570 10665 Y	
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CONVAIR FORT WORTH

CONVAIR—FORT WORTH
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TABLE II. NAS 177 RIVETS 17 4130-150 TABULATION SHEET CONVAIR - FORT WORTH

Page 38 FGT-2454 180 STEEL 1 H.T. ALLOY TYPE OF FAILURE 5280 tensile 7420 10360 bearing 7450 10820 7430 9980 7430 10390 7 9800 | 2800 | shear | 10700 | 3600 | 10250 | 3200 | 17960 18480 shear 17960 18580 17960 18685 Y bearing 9220 13800 shear 9000 14380 10180 14140 9470 14,110 Y Shear 17800 19200 s 17940 19480 ---- 19060 17870 19250 5360 5280 5310 4720 4680 4665 ULT. 165 4600 YIELD E/D DIA.0F Y RATIO FAST. 6 15 3/8" 20 512E OF PLATES 2X55/6X.036 2X5X6X.160 2X576X-125 2X5%5X.063 2 X 5 // 6 X, 080 2X556X-180 2X5 1/2 X,032 TYPE OF FASTENER NAS 177-12-8 4-841-1 Argi 5-821-1 AVg Avg 5-857-1 Av9 AYG 20 30 AVG Arg 5 35-1 12 45 30 1 4-811-1 SPECIMEN 3 --0 ı 4 5 5

N CONVAIR - FORT WORTH - TOON T-NAS 177 FRIVE - S IN 4130-150 KSI H.T. ALLOY STEEL

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				Fag 39 FGT-245	
3/8" 4330 4425 bearing 3/8" 4330 4425 bearing 2570 3990		7520 11640 shear 7460 12380 7490 12010 Y 14450 shear 8850 14330	8850 14275 Y 8600 14060 shear 7820 14160 10600 14080 9010 14100 Y	13900 17630 shear 12400 16880 14 120 17280 13470 17265 	Y 1725018620 Y 1725018740 Y
NER PLATES RATIOFAST. -12-8 2X5 % X:036 2.0 3/8"	2X5½X063	2 X 5 ½ X. 07] Y Y Y X 2 X 5 ½ X. 080	2 X 5 ½ X .090	2X5/2X.125	>>>>>>>>>
SPECIMEN NO FASTENER 1-823-1 NAS177-12-8	2-847-1 -2 -3 7 Avg	2-839-1 7 Avg 2-831-1	2-819-1 -2 -3 -3 7 Avg	2-803-1 -2 -3 4 Avg 3-843-1	1 Avg 1

TABULATION SHEET TABLE II CONT-NAS 177 RIVETS IN 4130-150 KSI H.T. ALLOY STEEL. PG S. CONVAIR -- FORT WORTH

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CONVAIR — FORT WORTH

TABULATION SHEET TABLE ILCONT-NASSIZZ RIVETS IN: 4130-150 KSI H.T. ALLOY STEEL, PG 4

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CONVAIR - FORT WORTH

TABULATION SHEET TABLE IL CONT-NAS 177 RIVETS IN 4130-150 KSI H.T. ALLOY STEEL, P. 5

SPECIMEN NO	FAST	EASTENER	PLA	FS	T X	25.2		955	HILDRE	华		
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8-845-1	t		2×51	2X 51/4X.160	7.		12650	12650 13080	Shoot			<u> </u>
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. 3				-				13120				
4 AV9			*	->-	-		12475 13210	13210	`			
3-837-1	•	•	2X5/	2 X 5 1/1 X.180	,	-	13980	13980 14120 sheat	Shear			
	-	-			4			V 1.				
3-803-1		NAS 177-8-8	2X4	18x.032	1.5	4	2850	3235	bearing			
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Y AYS			>	•			2645	3220	^			
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4-825-1			2X4/	18X.050			2940	5945	bearing	1		
				_			3480	6100	-			
£-							2860	5720				
1 Ava			>	`		•	3090		_			
				10.0	-		T.					
4-815 -1			2447	8X.063			8400		9180 bearing			
		-	-				8350					
5-3-3											2	
Y A19		-	>	>			8375	8540	^			
2. 12. 12. 12.		-										
5-825-1			2.14/	2X4/8X.125			10400	1040013480	Shear			
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5-3							10550	0550 12520		\$14 \$314		
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1-817-1			2 X 5	X.040	2.0		3480	5760	beating			1
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CONVAIR—FORT WORTH

TABULATION SHEET TABLE IT CONT-NAS 177 RIVETS IN 4130-150 KSI H.T. ALLOY STEEL, Pg 6

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CONVAIR—FORT WORTH
TABULATION SHEET TABLE II CONT-NAS 177 RIVETS IN 4130-150 KST H.T. ALLOY STEEL. pg 7 CONVAIR — FORT WORTH

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	NAS 177-6-8	1/2/4	24X.036 Z	7.0	2.0 7/16		27001	bearing		-		
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SHEET TABLE III-RIV TYPE OF SIZE EASTENER PLATE RIV 165-12-12 2X5% 2X5% 2X5% 2X5% 2X5% 2X5% 2X5% 2X5% 2X5%	165 RIVETS IN #130-150 KSI H.T. ALLOY S SE RATIO PIAOF VIELD ULT TYPE OF SOBOLISE SEATING 7420 11540 bearing 7430 11540 bearing 7430 11540 bearing 7430 11560 tensile 8120 11200 13980 tensile 11200 13980 tensile
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851-1 851-1 -3 4 Avg 4 Avg 6 Avg 6 Avg 6 Avg 7 Avg 6 Avg 7 Avg 7 Avg 8 Avg	7430 11430 7430 10890 V 11960 tensile 930012160 871012030 V 1120013980 tensile
-851-1 -2 -3 4 Avg 4 Avg 4 Avg 649-1 -873-1 -873-1 -2 4 Avg 7 Avg 849-1 -2 -2 4 Avg	930012160 812011980 871012030 V
-2 4 4vg -2 -2 -2 4 4vg 4 4vg 4 4vg 4 4vg 4 4vg 4 4vg 4 4vg 7 2 x 5 76 7 4 4vg	9300 2160 8120 1980 8710 2030 V
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-873-1 -873-1 4 Avg 849-1 2 X556	1030014200
-873-1 -873-1 -849-1 -849-1 -3 + 4v9	1103014025
-2 -849-1 -3 + Avg	12900 16400 hearing
	12180 6100
	12540,16250 Y
	26800 30600 shear
4 Avg	23400 30850
	2373030850
6-833-1 2x536x.312	. 27750 30150 shear
24	26300 30250
	2718030180 Y
1-885-1 2X51/X,032 2.0	2 4730 4900 bearins
-2	4460
Y 4V9 Y Y	Y 3230 4920 Y

Page 46 FGF-2454 Pg 2. ABLE III CONT-RIV 165 RIVE - 5 IN 4130-150 KSI H.T. ALLOY STEEL 哥是是 1252016310 bearing 6080 1040 bearing 4920 bearing -- 15280 bearing 16210 30150 shear 2550029750 2085029950 Y --- 30500 shear 4305 shear 1625025850 shear 1070016820 1070016820 1135016485 1495025000 1570024550 1563025135 3820 4355 4420 7800 14200 6000 14040 690014505 2850030100 2800030700 2825030435 4400 4630 4330 YIELD ULT 4720 4280 4340 4220 4200 RATIO FAST. 5/16" 5 2X5% X.080 2X5% X.063 5% X.180 2X5 727.032 2X5% X.125 -12-12 2X5/XX.036 2X58X.071 2 X52X312 813F 85 * 2 X OER NER 3-853-1 RIV 165-10-12 RIV CONVAIR -FORT WOR TABULATION SHE 2-883-1 AVS AVB AVB 3 Arg AVG SPECIMEN NO. Axg 3 72 3 2-877-1 3 2-849-1 Avg 2-879-1 3-863-1 -3 1 7 -873-1 3-817

CONVAIR -- FORT WORTH

TABULATION SHEET TABLE TONT-RIV 165 RIV TS IN 4130-150 KSI H.T.ALEOY STEE

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CONVAIR—FORT WORTH TABULATION SHEET TABLE	SPECINEN NO FASTENER	RIV 165		10	Y A79	1-815-1	-2.	, E	y Av9	1-819-1	-2	3	Ava		2-881-1	-2	23	1 A Y a	2-865-1	2-853-1	-2:	5	Y AY9	~	3-867-1			11/10		3-825-1		Y AV9 Y	The state of the s	

CONVAIR — FORT WORTH

TABULATION SHEET TABLE III CONT-RIVISS RIVE 5 IN 4130-150 KSI HT ALLOY: STEEL

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SPECIMEN NO FASTEN	FR 512 FOF	E/PO DIA OF	D14.07 E45 T.	VIELD L	12T TYP:	YPE OF		pg 5.
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-3				13500 136	13360			
V AVG	->-			12470 13340	340 1			
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6-843-1	2X478X.250			12100131	13060 shear	<u>`</u>		
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CONVAIR — FORT WORTH

TABULATION SHEET TABLE III CONT.-RIV 165 RIVE S IN 4130-150 KSI H.T. ALLOY STEEL

E/D DIA:OF VIELD ULT. TYPE OF PAGE 185 185 FAILURE	810012580 bearing	705012500 1	1058013140 shear	1022012960	13240	10400 3 10 Y	13050 shear	. 1224013260	1293013120	V 1258513150 V	F 3/2" 2560 4800 1.21.22	9030 4790		! 1		621011040 bearing			631010910 Y		7200 7420 shear			7340 7300 7350 y	7340 7350 y	7340 7350 y 7320 shear	7340 7350 y 7320 shear 7380	7340 7350 7350 7350 7350 7350 7440	7340 7350 Y 7320 shear 7380 7440	7100 7340 6050 7350 y 7100 7320 shear 7110 7380 7250 7440
SPECIMEN NO FASTENER PLATES RA		Y Arg	2-857-1		2	Y Arg	3-827-1		2-3	Y 4V9	1 % V4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 % . V A 4 4 4 % . V A 4 4 % . V A 4 4 % . V A		16.	Y Avg	5	5-881-1 1/2/4/21/1090	-	5	Y Avg	6	5-001-	-2	-2	3	-2 -3 V AV9	-2	4 4vg V V V V V V V V V V V V V V V V V V V	4 149 4 149 1 1/2 149/21	-2 4 Avg -811-1 -2 7 Avg 7 Y	-2 4 4vg -811-1 -8 1-1 7 4vg y y

TABULATION SHEET TABLE THE CONT-RIV 165 RIVE SIIN 4130-150 KST. H.T. ALLOY STEEL CONVAIR — FORT WORTH

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CONVAIR — FORT WORTH	CONVAIR—FORT WORTH TABULATION SHEET TABLE III CONT-RIV	+- PIV 165 PIVE					
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SPECIMEN NO FASTENER.	75	RATIO PAST.	I ELD	ULT: TYPE	E OF URE		8 84
	174.44.160	5 332	5150	5400 shear	1		
13.			1	5345			
A19-	>			5360 Y			
1-640-1	11/2 XA1/2X.250		2200	3775 shear	1		
-2							
-3				4960			-
Avg	, , , , , , , , , , , , , , , , , , ,		2970	3740 Y		+	
1-811-1	14X45/1,050	2.0	3075	5305 bear	ins		
-2	\		3280	5345			
-3				5320			
Y Arg	*		3180	5320 Y		+	
2-831-1	114X456X.125		1	5220 shear			
-2			5200	5260			
-3			5250	5350			
Avg	, , , , , , , , , , , , , , , , , , ,		0.5	5230 Y			
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CONVAIR -FORT WORTH

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-3			1675	2620	
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3-849	11 X 4 7/6 X.036		1615	2110 bearing	
-23			1445	2125	
- 3			1525	1960	
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4-871-	1 × 4 × 6 × 0 63		2375	2850 shear	
-2			2450	3185	
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CONVAIR—FORT WORTH TABLE IV. AN 509 SCREWS IN 7-7 PH, 180 KSI H.T. STAINLESS STEEL.

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NER.	816-22																					>		509-616-20							,	>			
TYPE OF FASTENER	AN 509-816-22						1									-						->		AN 509								λ			
		-2	121	AVG	7-1	-2	1	AVA		23-1	-2	1.3	AVG		3-1	-2	-3	Avg	-	217	10	3	AYG	1-698		13	400		-1		3	Avg	`		
SPECIMEN NO	9-82	-	an extreme the second allocation of allocations and allocations are consequently allocations and an extreme as		7-83			->		7-823			7		7-803			>	700	20.00				7-86				Application for the control of the c	7-85	-	And the state of t				and the second s

CONVAIR—FORT WORTH TABULATION SHEET	WORTH SHEET TABLE	V. CON	EFAN 509 SCREWS IN 17-7 PH, 180 KST. H.T. STAINLESS STEEL	SCR	-W5 IN	17-7	71 180 Ke	ļ	,
)		100 00 00	KHIL STAL	NLESS STEE
SPECIMEN NO FAST	TYPE OF FASTENER	SIZEOF	E/P	DIA: OF FAST.	(IELD)	ULT. TY	TYPE OF		pg. 2
		2X5/2X.123	5 2.0	3/8"	9350	0	shear	The second secon	And the state of t
			•,		8250				the company of the control of the co
-3			,		7950 14560	560			
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-811	7 /	2X5%6X.04	40 1.5			4820 tes	tensile		*
-2						4995			
5-3					- 1	4855			The second secon
Avg		>				4890	>		
853-1		2×5%5×.06	63			3330 bea	bearing		
7.7					6680 5	3220		,	Manager was allowed by the same of the sam
2		-				3050			
410	>	,				9220		71.	
	A E								
	4N 509-516-19	2×532×0	3.5	5/16"		4425 bec	bearing		
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m					- 1	4180			
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17.170		0 V F 3/2 V 000				7 0 7 7 1			
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1.2						1400			the second secon
) '		>			7 7700	1200	-		
43						700			
7-873-1		2X5/4 X.063	53 2.0	/ ₁ / (1)	5510 8	8840 sh	Shear		
-2						8200			1
5	2			:		3500			
AVG		<u>,</u>		-		8845			I
				-					G'
857-1		2X5/XX.090	30.		010006	10480 sh	Shoar		ge I-
-2							/		24
u)						9080			54
AY9 ×	>	^	>	>	,	9840	>		
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CONVAIR—FORT WORTH
TABULATION SHEET TABLE TOONT-AN 509 SCRE SIN 17-7 PH, 180 KSI H.T. STAINLESS STEEL

_	PLATES	BATIO	11.	Y 15.10	165	FAILURE			6 64
8-871-1 AN 509-416-18	284	.5	//4"	2850	3340	3340 bearing			a statement of the contract of the statement of
-2			-	2275			egiptivi and colombia de la colombia	e de	Brillian Branchistan and Brillian and American
Ara				2560	3240	•			
	2X4 8X.063			3750	6120	shear	,		,
-2				3540	6100			,	
5.3		. K.		3600	6040				ŕ
414	>			3660	0609	>			x -
9-845-6	2X4 1/2 X.090	_		4500		Sheat			
1.2				5260	6580				
Avá	>	>		4930	5620	·>-			
7-877-1	2 X 5 X.063	2.0	A	2420		bearing			
-2				1280		,			
-3				1150	6120	,			Order and the control of the control
4 v 9 V				1620	6120	-	1		
		-							2
6-875-1 AN509-10-17	7 1/2 x 4 3/x 032		3/6"	1800	2890	bearing			
	-		nt.	2550	2820				the state of the state of
-3				1650	2780				
. A va	>		aphd-	2000	2830	>	2		
6-863-1	12 X474 X.036			2820		beating			
-2			•	[ľ á		
-3				2000	3250				
479	>			2410	3185	.			
	11/2×4/34 X.050			3950	5030	bearing		,	
-2,				3340	4940				
-3		T		3800	5310				
Ava	^			3700	5090	, >-			
,,	1/2 X 4 3/4 X . 053	=		2610	3315	shear		•	
-2:		it.		2545	3335				F
-3				2300	3100				GT
7.0				2485	3250	λ,			zе Г-
	11/2×4/2 x.090			4680		Shear			24
7.					4835				54
		* 1741	٠, هـ	4600	5080				
4V9 Y Y	>	>	>	4640	4900	->-			
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Ţ	PLATES	成代の野野光	PSI	PSF FAITURE		191
8-841-1 NAS 11/- 14-0	2-8 245% XQ36	1.5 3/8"		5200 bearing	Section of Magnetic	
-2		-	I	930		
-3				4405		
Avg			4105 4	4845 7		1
4-803-1	2 X 5% X 050	-	1	940 1001 1110	TOTAL TELEVISION OF THE PERSON	
-2	-	-	7150	ECO COLOROL MA		
-3			-	8860		
Avg	*			8750 1		
	2000					
9-071-1	CONVERNOS	-	1010 1220	LU bearing		
1.5	++++	+	04/0/0000	7000		
2-3			6350 0440	440		
Avg		- - -	0000	775 1		
1-618-6	2X55/kx.071		8070 12820	920 hoaring		1
-2			8030 12080	I .		
-3			7150 118	800	and and an order	1
Arg	*	-	775012230	230 Y		
9-807-1	2 X5% X.090		1260015060	260 shear		
-2			1205015120			1
5			1242013	200		
Avg	*	•	1236014630	530 1	Total Control	8
6-867-1	2X5% X.032	2.0	4630 4	4905 bearing		1
-2				5355	DC-7-	L
6-1				5575		L
479	>			5280 1	A	
					10,000	
6-803-1	2X5/2 X.036		10.74	5600 bearing		
-2				935		
6.				5465		1
AV9 1	>	<u>,</u>		630 Y		
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CONVAIR—FORT WORTH
TABULATION SHEET TABLE V CONT-NAS 177. RIVETS V17-7, PH. 180 KST HT-STAINLESS

7-817-1 M45177-12-8 2.4544.001 2.0 38 5120 12800 sheat -2	MEN NO	SPECIMEN NO FASTENER	SIZETES	ESPIO	PAST.	150	737	ULT EXILERGE		pg 2
1	817-1	NAS 177-12-8	2×5/2×.07	2.0	3/8"	5120	2800	shear		4
2 X5½ X080	-2			-		6160	3260			
2X5½x080 9720 13020 shear 9250 13250 5 9250 14200 1 11820 14300 1400 shear 11820 13900 1 1200 1400 shear 1200 1400 shear 1200 1400 shear 1200 14520 7 1200 14520	-3			e#		5650	2980			a shadner o
2 X5½ x080 9730 3020 shear 9820 3450 3	1. AV9		*	1	-	5640	13010		Margar Street	
XX5XXU00 9320 3260 9300 4200 9600 4200 1 9600 4200 1 9600 4200 1 9600 4200 1 1 1 1 1 1 1 1 1			1000							
1	813-1		ZX272KUD	7	-	9750	3070	hear		- T
2 X5% X.090 11820 1040 shear 1200 14500 1 1 1 1 1 1 1 1 1	-2			-		9850	3260			
2 X5½X090	-3					9800	4200			
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12.180 13800 12.000 4500 12.000 4500 12.000 4500 12.000 4520 12.0000 4520 12.0000 4520 12.0000 4520 12.0000 4520 12.0000 4520 12.0000 4520 12.0000 4520 12.000	805-1		2 X 5 1/2 X .09	0		11820	4040	hear		
12000 14500 Y	-2		-	-	-	12180	3800			
1	-3				i i	12000	4000			
	* Ava				1-1	12000	3950			
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12640 14920	1-108-	-	2X5/2X112	2	~	11650	5440	hear	and the same plants of the	
	-2					12640	4820			April Company
	-3					12000	4520			
	1 419	> •	*	>	•	12010	4920	Ļ	W. Co.	
XX572xx032 1.5 3/6" 3720 3500 bearing X										
2X5%xx050	-835-1	NA5177-10-8	2X575X.03		3/16	3720	3500 6	earing		
2.X5\%2\X.050 \	72		+			3060	3470			
2X5%2X.050	5-3					3575	3800			
2X5%2X.050	1 A19		*	4		3450	3590	Ý		
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2X5%2X.053 6970 7980 bearing 6580 8760 8160 9560 Y Y Y Y 6570 8770 Y	AVE		^		_	0109	7240	>		
6580 bearing 6580 bearing 6580 8160 8560 kg kg kg 6570 8170 kg kg 6570 8170 kg kg 6570 8170 kg				:						FC
6580 8760 6160 9560 7 7 7 7 6570 8770 7	1-829-1		X.05	23		6970	7980	pearing		T
Y Y Y Y 6570 8370 Y	1 -2		-			6580	8760			24
* * * * * * 6570 8170	5-					6160	9560			54
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CONVAIR - FORT WORTH

TABULATION SHEET TABLE TOONT-NAS 177 RIVET IN 17-7 PH, 180 KST H.T. STAINLESS STEEL

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			57.5	CANADA PAR	10000	1000								, mar 100 mg			4		1																
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FAILURE	Shear		,		tensile	V				beatin	47. (7-		,		bearing	1. 1. 1. 1. 1.		,	į	Shear	25.11.25			•	tensile	1 77		*	bearin	1 7	*	hodring			
52	10400		10000	2	7520	7120	7340	7330	4.4	4720	4860	4840	4810	2.4.2	7020	7520	7420	7320	25.6	12600	11780	12480	12285	20.20	11200	862010960	895010500	068010998	3445	3855	3400	0000	4390	4160	4180
165	9210	9040	9125	7	4660	4600	2480	3910		3160	3370	2550	3030		5340	4400	4730	4920	. 1.4.	7430	7260	7630	7440		8400	8620	8350	8660	3330	2270	1870	2350	2500	2350	2400
FAST.	5/16"		T	9.1		110			7							*					5:							_	1,4%	-		Ŧ			_
RATIO.	.5		100					•		2.0					1				_			-	-		_	-			1.5			-			>
LATES		7		7	x5%x,090					X54X.040			,		x 5% x.050	11.0		×	\dashv	X5% X.080	100				X5%X.090			.	x4 1/4 X.036			X4 % X.040	, -		<u>-</u>
9	10-8 2x	100		-	2,		10.			2	~				2,					2,	3:				2		-	*	-8-8 2			0	1		_
FASTENER	NAS 177-10-8			100							7.7										1	-	-					,	NA5177						<u>~</u>
SPECIMEN NO	1-218-6	-2	1 AV4	10 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	1-808-1	7-0-0-5	-3	1 Ava	S Y A 24	1-1-9		-3	1 419	, , , ,	7-841-1	7.4.1.2	6-	1 414		7-815-1	2-1 -5-6	-3	Y AY9		7-807-1		٤.	1473	8-825-1	1 -2	1 Avg	100-00	2	6-	1 Av9

CONVAIR—FORT WORTH

TABULATION SHEET TABLE \(\times CONT. NAS 177 RIVE - IN 17-7 PH, 180 KSI H.T. STAINEESS STEEL

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CONVAIR -- FORT WORTH

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YIELD U			2200 2		1085		2015 2	1640 2	2011		_		105			1 1	2		7	1360 2		1470 2	2125 21				1725 2	\perp
DIA.OF FAST	3/16"		-										•															
m A	50 1.5	+			3.2			-		3			7	\\ \		>	5			2			0			2		
SIZE OF PLATES	1/2X482X,050		>		1 X 476 X.032			> -	212	20.001120		>	1 × 4 1/2 × 063	200		>	1 X4% X.025	{	>	1 X 4 1/2 X.032	ſΙ	>	1X4%X.036		>	1X42X.063		-
TYPE OF FASTENER			,		NAS 177- 4-8																							
SPECIMEN NO FA	1 1	?		7	8-843-1 NA	-2	-3	1 AVG	-	8-031-1	1.	× 4×9	1	2-2	-3	Y Avg	6-827-1	-2	4 419	6-825-1	-2	4 419	6-865-1	?	Y AV9	7-835-1	C.E.	

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CONVAIR—FORT WORTH
TABULATION SHEET TABLE VI-RIV 165 RIVETS IN 1 7 PH. 180 KSI H.T. STAINLESS STEEL

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165	1300	11300	9200 11440	8950 11350		14860	15000	14800	11530 14890	11000	1000	1000		25000	25250	25500	2045025250	000000000000000000000000000000000000000	1000 25400	24350	1030024780	15220	8100 15580	7650 14540	787515180		16000	15480	12430 15740		
TIELL Pos	8520	9120	9200	0368		11200	12000	11400	11530	0007	1400 1000	4620	14270	21400	19500		20450	0000	200	8	10300		0019	7650	7875			12480	12430		
RATIO FAST PS	3/6"						2		-																				>		
24T10	1.5																				•	00	<u>-</u>					1	>		
	7	-	-	-		X.071			-	VE 5. V 000	7.000		-	X.112			-	755/ Y 10E	_		-	170 X			-		X.080		>		
PLATES	2X5%			•		2X528X.071			>	2 1 5	7	-	-	2X55x111	•		•	2 155/			>	7 X 5 1/4 X 071	•		•	,	2×5%		_		
	2	1								+	-	+-								,					-			+	-		-
ASTEN	RIV 165-										+	-													i			-	-	2.3	
N NO F	9-1 R		5	Ava	,	1-6	-2	-3	449		- 1	10	27.4	3-1	-2.	?	Avg	-	12	12	Avg	-		100	AYG		7	3	A.Yg		
PECIMEN NO FASTENER	8-879-1			1	1	9-849				0	7-841			9-803				4				7-965					7-863				
SPECI					-	6				•	2			9-1		1						7_6	5				7-8				

CONVAIR — FORT WORTH

TABULATION SHEET TABLE II CONT.-RIV 165 RIVET IN 17-7 PH, 180 KST. H.T. STAINLESS STEEL.

SPECIMEN NO		PLATES		RATIO	FAST		183	FAILURE			200
7-851-1	RIV 165-12-12	2X52X	060X	0.0	18		21020	21020 tensile	-		
12.2		+		1	-	12200	2000				
1 Ava			_			4 180	21200	X		10000	17 5,310
								7		The State of the S	
1-1-1		2X5% X.	125			21400	26750	tensile		1,160	
-2						2320026550				1.00	
-3						2050027550	27550			10000	
Y AYS		~	•	_	>	21700	26950				
8-881-1	RIV165-10-12	2 X 5 3, X, 032		5.	5/6"	3870	4180	bearing			
	-			_	1	4100	4305				
6-		_				4300	4770			1000	
AV9			,			4090	4420	,			
		-5	- 6	1	+	0000	1				
0-8 3-	-	A10/01A	7.040	+	1	מחשב	2342	pearing	1		
-2				1	1	4410	4950				i i
-3					-	4430	4875				
Y AY		*	>	1	1	4680	2060	x			
9-855-1		2 X 5 3, X.050	.050		-	5920	7640	7640 bearing	-		
2							7960	,			
2						5930	7840				
1 419		*		1	+	5925	7810				
9-855-1		2X532X	X.063			6200	1460 bearin	bearing	-		
-2						7800	780011600				0
6-						5750	10720				
1 419		,	,		-	6580	11260	۲			ľ
		- 2	_	1	-				-		ag GT
9-839-1	+	ZX552X.030		1	-	4700	0270	Shear	-		-4
7			-	+	-	4350			1	-	
5				_	-	4500	8400				4.
1 419	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	X	>	<u> </u>	X	4530		λ.	-		
			+	T					-	1	
				ľ						-	

CONVAIR -- FORT WORTH

TABULATION SHEET TABLE VI CONT-RIVISS RIV TS IN 17-7 PH, 180 KSI H.T. STAINLESS STEEL

SPECIMEN NO		EST	RATIO.	FA5.19	124	120	FAILDRE		664
9-5-1	RIV 165-10-12	275%11.125	15	\$16"	14650	18340	shear		W. 1.1
-2				-		19100		100	100
Y AV9		<u>.</u>	•	-	14650	19020	•	1000	
1-828-7		2×5/4×032	20	+	22000	4170	*		
1000		-	_	17.	3		2017637	Total Control	1000
18-					2860				-
1 4vg		,			3280	*	,		1000
6-849-1	1	2X5/XX.040	+	1	4330	-	hearing		-
-2				_	4760			1	100.00
1 Avg		>	-		4545	6230	-		
7-885-1		2×5/4×.050				8690	bearing		
-2					6060	8520	-		
63		200			6700	100			
Y Avg		y v			6380	8660	,		
7-827-1		2 X 5 1/2 X.063	+		2600	2500 0720	Shoor		9
-2		-			3850	3850 10600	15.00		-
6.					6900	10220			
Y AYG		>	1	-	4780	478010515	>		0/0/
7-867-1		2 X5 1/ X.071		-	4500	1300	hoor rin		
1-2			-		5900	11420	6	3	
5-					8800	13060			-
1 419		*	+		6400	640011925	*		
7-855-1		2×5/4×.090			13550	18900	Shear		
-2					10200	18800			
5.					14950	18240			
Y AY9		<u>*</u>		1	12900 8650	18650	,		64 245
1. 5-1		2X5/X X.125			12750	12750 12900	Shear		
7					12450	13080			
-3					13000 13540	13540		177	
V 4 V 0	_	>	>	>	0000	クレーダ	,		

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TABLE TON SHEET TABLE VT CONT-RIVIES RIVE

SPECIMEN NO	FASTENER FASTENER	SIZE	PES	EAPLO EAST.	F YIELD	ULT TYPE	EIGE		4 84
8-883-1	RIV 165-8-12	2X4/8	X.03	1.5 14"		3925 bearing	jui g		1
1 449			•		3450	3825	1		30,000
4-957-1	+	2 X 4 7/2	X.050		0033			4 FOLDS	8
		-			5030	6360	8111		
-3					5040	7000			
* AV9		•			5560	V 0778			13
9-823-1	-	2 × 4 1/3	X.071	-	5600	9660 bearing	001		
-2				-	1	9760	-	1111	0.000
	i e n			-	1	10000			
Y AVG	.,	,	,_		5600	¥ 7086		1	
									-
9-843-1		2X4/8	7.090		4160	6040 tensile	1/4		
2.				-	4300	7240			
.3			-	-	5250				
ANG	+	•		+	4570			į.	110
0-001-1		2 1 4 7/4	X.125	-	000	140013000	1	+	
-2			20	-	10850	2540	+	-	
1 AY9		,	,	,	1010				
							-	1000	
1-118-9		2X5	X.032	2.0		3675 bearing	ina		
-2					2160	3315			
.5.					1430	3385			
Y AVS		*	•		1795	3450 1			
1-158-9		275	X.040			5180 bearin	911	-	
7.7						-			
Y Arg						5170 Y			ge T-2
7-887-1		2 X 5)	X.050		1	8420boaring	17.0		
-7					4160	8350			
5					.	7920			
1 100	, ,	^	>	*	4160	2220			

STEEL	264				1	1	aluna.	1	1		1	-	1		1	1			.	1	1		11	FG	ge T-	24	6 54	1
	2			100000	1							-	Harris and Marie and the same		+	-				-								
	TYPE OF	bearing	*	Shear			hear		,	177	,			6100	- Jear	-	>	guing	hoaring	"	Shear		earing	Paring				1
	ULT PS	1060	1220	1040	\exists	- 13	S	000	7350 2350	42 0000	15	213120	963013140	7200	1780	7320		3120	3770	3410	3635	3605	6400 6	3390	3190		3340	1
	即6年7月5日		2500	5480	7619		528	2707	735	040	1096	988	7696	3/5 628	2007	5316	5850	1570	2050	2050	1950	202	V 4410	5/2 2780		2700	Y 2610	-
The second second second	RAPO EV	2.0 7			+	1	+	-		+				4)-			2.0					-	15			_	
	科科	690	-		,		050.4 CXX	-		X 5 X.125	i-		,	14×49×2090	2000		>	1/2X474X.032	18 X4 X X O40				14X47XX.050	RIV 165-5-12 14X478X.036			,	
ļ	-	-				-	, X			2 2			, , ,	XII 51-9-151/11				1/2	72				Y 1/2	5-5-12 1/4			٨	
	SPECIMEN NOFASTENER	-1 RIV 165	-7	-3	Avg		-	7.	449		-2-	-3	Axe			-3	4v9	-	17	-2	-3	Avg	-1 ×	-/ RIVI6	7.5	6)	Avg Y	
The second secon	ECIMEN	7-875			4 A	1	1-623-	1		7 - 5.	-		Y .	0-013-	-		¥ .	6-873-	6-853-1				7-889-	8-829-1			1. 1	

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TABULATION SHEET TABLE II CONT-RIV 165 RIVETS IN 17-7 PH, 180 KSI H.T. STAINLESS STEEL

964			THE RESERVE OF THE PERSON NAMED IN	A STATE OF THE STA										The second of th								RG	7-	24	154	1	
ULT. FILER OF	3990 :Fing		3950	3390	2080 shoot	2250	2280	2205		3135 3hear		3010	3090														
AST. IELD	3460	3230	1.1			1500	1565			2400	2360	1	2380										-				
RATIO PAST.	2 2.0				6 1.5					3	1		+	+	1												
\$125-65	14X45X03			7	14x4/6x.036			,		14X+X4X.063				1		-				-11							
ESSE RE					8-877-1 RIVI65-4-12				T																		
SPECIMEN NO	8-823-1	7	?	Avg.	8-877-1	-2	-3	AVG		8-853-1	-2	-3	419	7 1 10 1													

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